

# Work Order ID 86925

\*86925\*

Page 1

July-09-12 2:48:59 PM

Item ID: D3238-31 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Plate  
 Start Date: 7/09/12 Start Qty: 5.00 \*5\* Cust Item ID:  
 Required Date: 7/27/12 Req'd Qty: 5.00 \*5\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3238	Rev C								

100 0.00  
 \*100\* FLOW WATER JET  
 Waterjet Memo 0.00 5 0 Jm 12-7-22  
 FLOW CNC Waterjet 1-Cut as per Dwg D3238 Dwg Rev: C Prog Rev: C 2-  
 Deburr if necessary \*\*\*Use cutting file D3238-21-23-25\*\*\*\*\*  
6061, 020

110 0.00  
 \*110\* QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00 5 0 Jm 12-7-22  
 Quality Control

120 0.00  
 \*120\* QC8- Inspect parts - second check  
 QC Memo 0.00 5 0 Jm 12-7-22  
 Quality Control

SMB  
 12.7.23  
 DAS  
 16  
 9-89  
 12/8/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86925

**\*86925\***

Page 2

July-09-12 2:48:59 PM

Item ID: D3238-31

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Plate

Start Date: 7/09/12 Start Qty: 5.00 **\*5\***

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 5.00 **\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				5	0	06/27-23	
<b>*130*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00				5	0	12/10/23	
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: 8537	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									

~~12/10/23~~  
06/27-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**\*86925\***

July-09-12 2:48:59 PM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 7/09/12      **Start Qty:** 5.00      **\*5\***

**Cust Item ID:**

**Required Date:** 7/27/12      **Req'd Qty:** 5.00      **\*5\***

**Customer:**

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

### Operation Description

## Set Up/ Run Hours

## Tool ID

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject Qty

Reject  
Number

**Insp.  
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

12/17/24 *[Signature]*  
MK  
12-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

July-09-12 2:48:58 PM

Page 1

Work Order ID: 86925

Parent Item: D3238-31

Parent Item Name: Plate

Start Date: 7/09/12

Required Date: 7/27/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-01-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.020  
6061-T6 Sheet .020

Purchased

No

100

sf

62.7360

0.024

~~0.1263158~~

0.25

Jun 27-22

Location

Loc Qty

Loc Code

MAT021

62.736

112442

14.736

119743

48

119743

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





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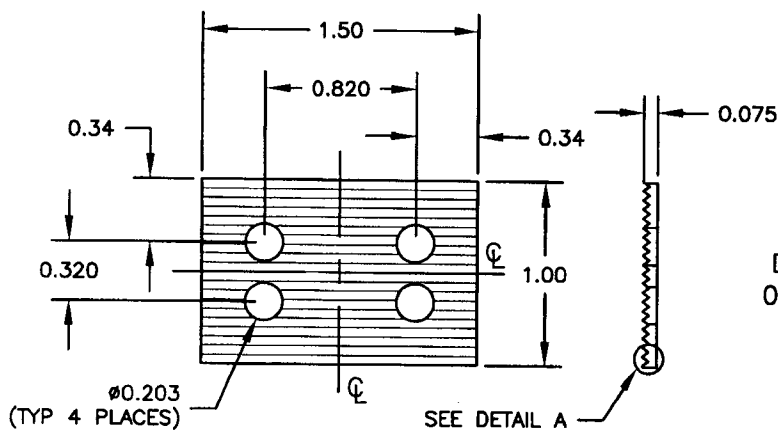
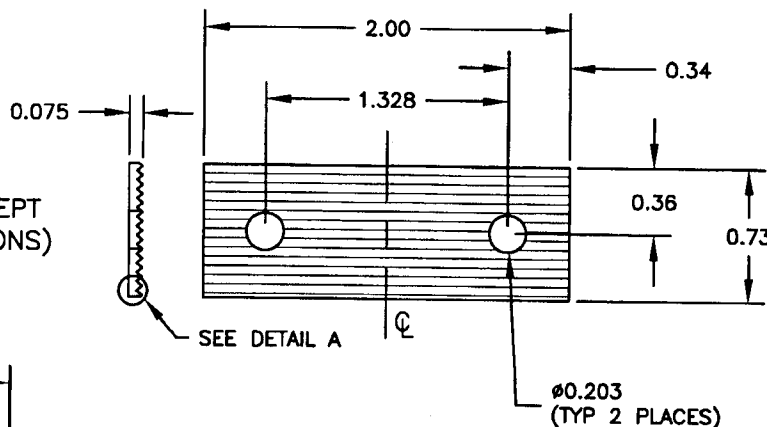
**NOTE:** Date & initial all entries

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

**RELEASED**

07.02.20

**D3238-1 PLATE (SHOWN)**D3238-11 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)**D3238-3 PLATE (SHOWN)**D3238-13 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)**NOTES:**

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:  
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S)  
-11/-13/-15/-31/-33/-35 PLATE:  
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)  
OR  
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR  
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT  $\phi$

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SHOP COPY

UNCONTROLLED COPY  
ENGINEERING  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86525 M-5  
12/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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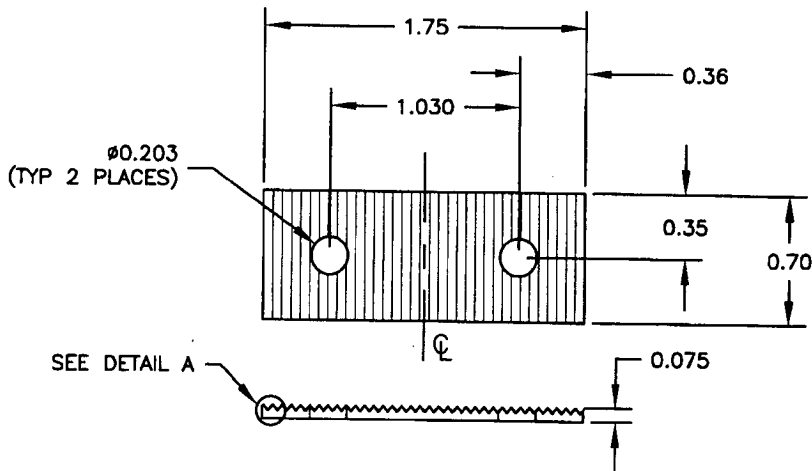
**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1

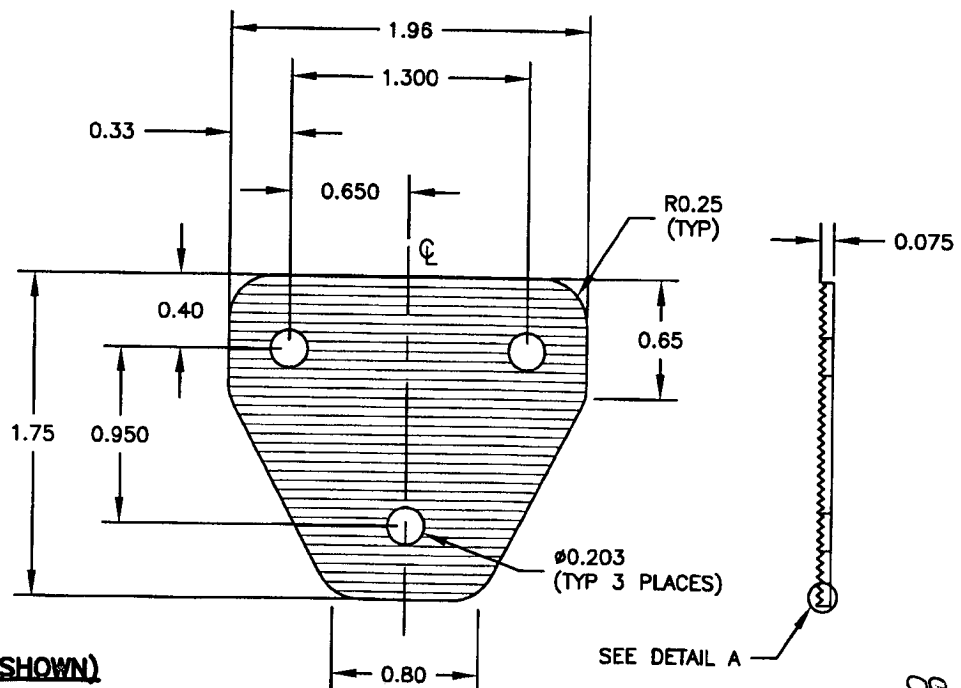
RELEASED

07.02.20



**D3238-5 PLATE (SHOWN)**

D3238-15 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)



**D3238-21 PLATE (SHOWN)**

D3238-31 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)

86925

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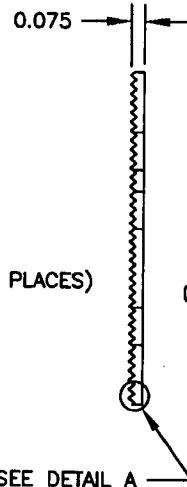
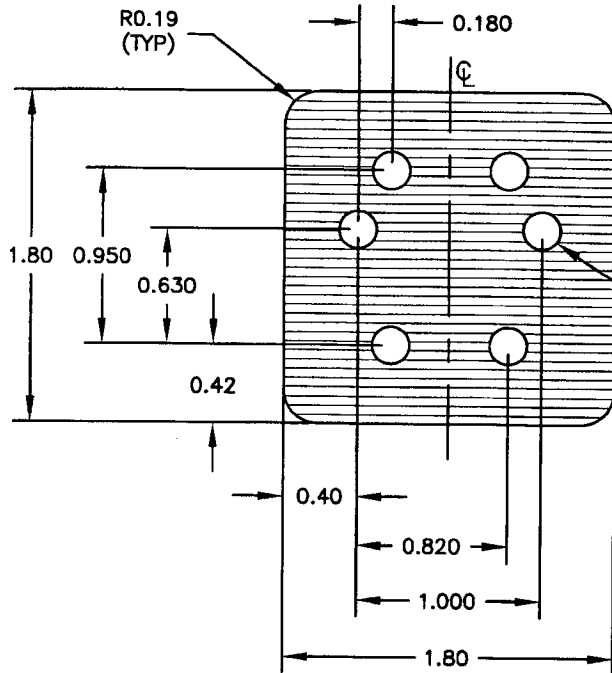
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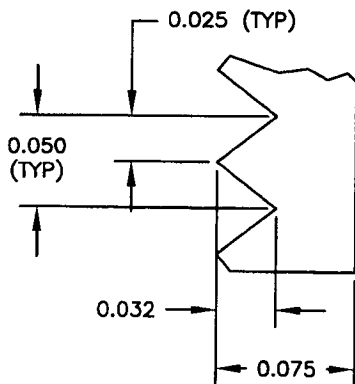


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1

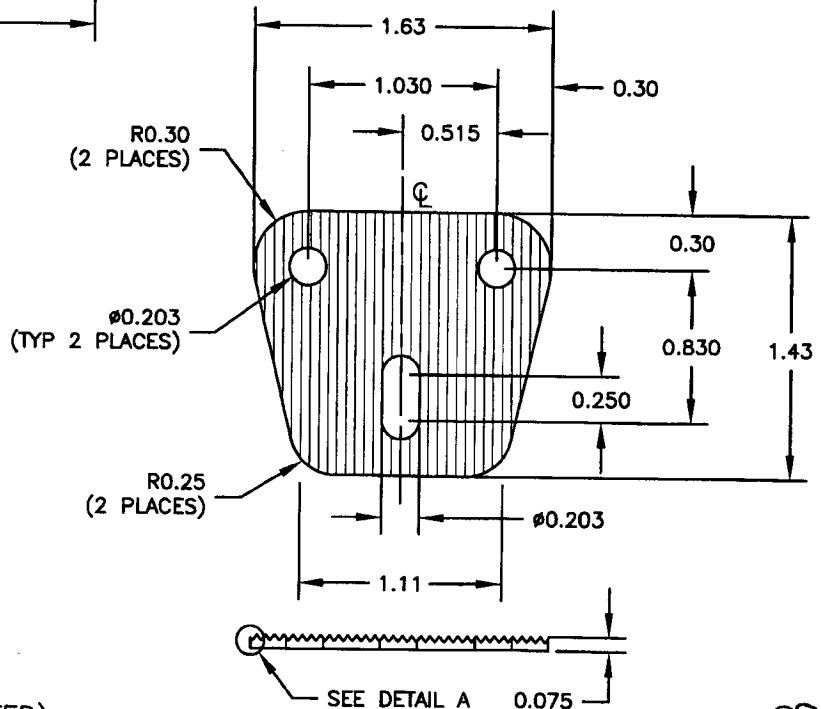


RELEASED  
07.02.20 #

**D3238-23 PLATE (SHOWN)**  
D3238-33 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**DETAIL A**  
RIDGE DETAIL (VIEW MAY BE ROTATED)  
SCALE 10:1



**D3238-25 PLATE (SHOWN)**  
D3238-35 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

06925

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